

Work Order ID 69837



Page 1

Friday, May 20, 2011 7:58:55 AM

Item ID: D3235-1	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Mounting Lug					
Start Date: 5/20/2011	Start Qty: 100.00		Cust Item ID:		
Required Date: 5/30/2011	Req'd Qty: 100.00		Customer:		
Reference:					

Approvals:	Process Plan: <u>CY</u>	Date: <u>11/05/20</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3235	Rev A

100	BAND SAW	0.00							
	Bandsaw	0.00							
Jeaspa Bandsaw	Memo								
	Cut D2423 extrusion to 0.820"								
	Batch:								

cut @ meter

CY 11/05/20

110	HAAS CNC VERTICAL MACHINING #1	0.00							
	HAAS 1	0.00							
HAAS CNC vertical machine #1	Memo								
	1-Machine as per Folio FA369 and Dwg D3235								
	2-Identify as D3235-1								
	3-Deburr								

P/O.14141

CY 11/05/20 100

120	QC2 Inspect parts off machine FAI/FAIB	0.00							
	QC	0.00							
Quality Control	Memo								

rec'd + inspect for transit damage
attached c/c to w/o.

104/4/22 (100)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69837



Page 2

Friday, May 20, 2011 7:58:55 AM

Item ID: D3235-1	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Mounting Lug					
Start Date: 5/20/2011	Start Qty: 100.00		Cust Item ID:		
Required Date: 5/30/2011	Req'd Qty: 100.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130	QC8- Inspect parts - second check	0.00				<i>COCAUTO</i>			
						<i>(+100)</i>			
QC	Memo	0.00				<i>28P019</i>			
Quality Control									

140	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	Memo	0.00							
Powder Coating									

START TIME: *12:45*
 OVEN TEMPERATURE: *320 OF*
 FINISH TIME: *1:15*

M 117745

100X ✓ M-11/06/23

100X ✓ M-11/06/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
							23 95	

NOTE: Date & initial all entries

Work Order ID 69837

Friday, May 20, 2011 7:58:55 AM



Page 3

Item ID: D3235-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Lug

Start Date: 5/20/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 5/30/2011 Req'd Qty: 100.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

100 ~~0~~ ~~PK~~ 11-6-28.

180

Identify as per dwg & Stock Location: ST

0.00



Packaging

Memo

0.00

Packaging

4/54/06/30 (100)

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/30 ~~PK~~PK 11-06-30
(100)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, May 20, 2011 7:58:52 AM

Page 1

Work Order ID: 69837

Parent Item: D3235-1

Parent Item Name: Mounting Lug





Start Date: 5/20/2011

Required Date: 5/30/2011

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP ☐ A ☐ 04.04.19 ☐ New issue ☐ KJ/JLM ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3235-1P  lug		Purchased	No			100	Each	0.0000	1	100			
D2423  Lug Extrusion		Manufactured	No			110	f	230.8900	0.0683	7.189474			

PLU/8/20 (100)

CL 4/105/20

Location

Loc Qty

Loc Code

MAT006

230.89

43722

161.5

45800

1

63005

68.39

7.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

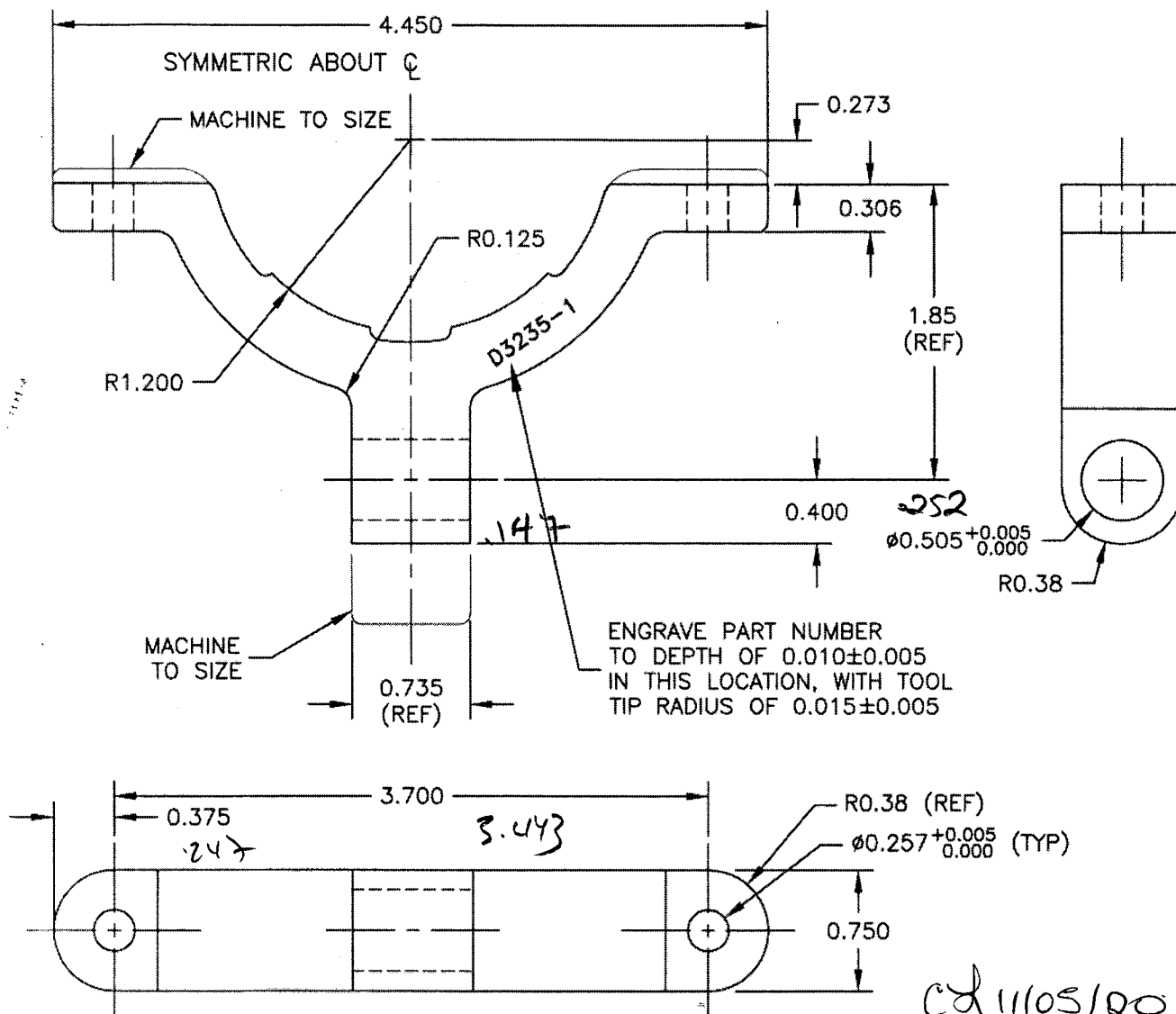
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3235	REV. A SHEET 1 OF 1
DATE 04.03.02		TITLE MOUNTING LUG	SCALE 1:1
A	04.03.02	NEW ISSUE	

RELEASED
040405



D3235-1 MOUNTING LUG

MAKE FROM EXTRUSION D2423

BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

CD 11105120
W10: 69837

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED, OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO14141

Purchase Order Date 5/20/2011
PO Print Date 5/20/2011

Page Number 1 of 1

Order From :
METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
WANKLEEK HILL, QC K0B 1R0
CANADA

VC-MET003

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	613 678 3957	Requisition Nbr	
Vendor Fax	613 678 3956	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
D3235-1P		lug	5/30/2011 Yes	100.00 Each	Yours ppd	\$13.9000	\$1,390.00
		Special Inst:	MACHINE AS PER DWG D3235 REV. A B69837				
D2230-1P		LUG	5/30/2011 Yes	100.00 Each	Yours ppd	\$18.9500	\$1,895.00
		Special Inst:	MACHINE AS PER DWG D2230 REV. G B69821				
D2230-3P		LUG	5/30/2011 Yes	100.00 Each	Yours ppd	\$13.6000	\$1,360.00
		Special Inst:	MACHINE AS PER DWG D2230 REV. G B69820				

PO Total: \$4,645.00

CERTIFICATE OF CONFORMITY
REQD UPON DELIVERY

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 5/20/2011

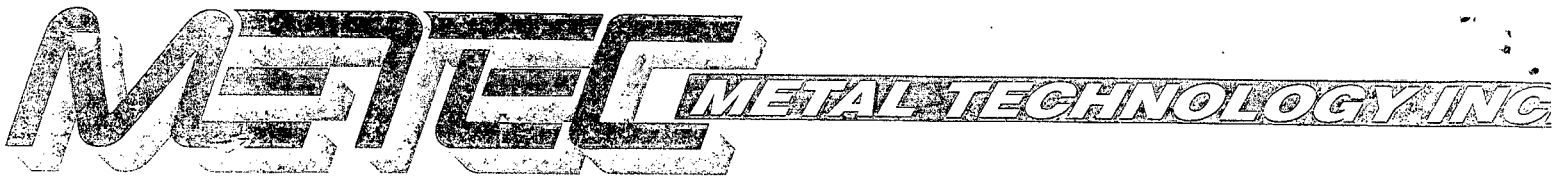


20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 18038
Date: Jun 21, 2011
Page: 1

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 14141	Sold By: Kueffer, Fabian
Shipped By: your truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3235-1 Mounting Lug Material supplied by DART: D2423 B63005	Each	100	100	
D2230-1 Mounting Lug Material supplied by DART: D2423 B63005	Each	100		
D2230-3 Mounting Lug Material supplied by DART: D2423 B63005	Each	100		
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

100

D3235-1

Mounting Lug

14141

MATERIAL: supplied by DART D2423 B63005

8/10/11

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Walz
Shigi Walz

Vankleek Hill, June 21, 2011